

Date: Friday, 08/08/2008 7:34:53 AM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	GUIDE
Job Number :	41072		
Estimate Number :	10367		
P.O. Number :		Part Number :	D31121
This Issue :	08/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3112 REV B
First Issue :	//	Project Number :	N/A
Previous Run :	35234	Drawing Revision :	B
	Type :	Material :	
	MACHINED PARTS	Due Date :	20/08/2008
Written By :		Qty:	10
Checked & Approved By :		Um:	Each
Comment :	Est. A 02.05.22 New Issue NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0625X01500	6061-T6 Bar .625 x 1.50
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Comment: Qty.: 0.2385 f(s)/Unit Total : 2.3846 f(s)

6061-T6 Bar .625 X 1.500"

Material: 6061-T6/T6511/T651 (QQ-A-225/8 OR QQ-A-200/8)

Bar ref DART spec M6061T6B

Batch 17101549

DJP 08/08/13

(10)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks: 0.625" x 1.500 bar x 2.625" long.

DJP 08/08/13

(10)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA233

Note: Engrave / scribe DART P/N on part as per dwg.

Deburr break all unmarked sharp edges .005 to 0.010

JL 08/08/15

(10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 08/08/15

(10)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

9mx 08/08/16

(10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 08/08/2008 7:34:53 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 41072

Part Number: D31121

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 08-08-18. (10)

7.0

POWDER COATING

POWDER COATING



M106442



(10x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:00
325°F
10:30

MF 08/08/18

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 08-08-18 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 147

8/8/18

(10x) SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/18

Job Completion



MF 08-08-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

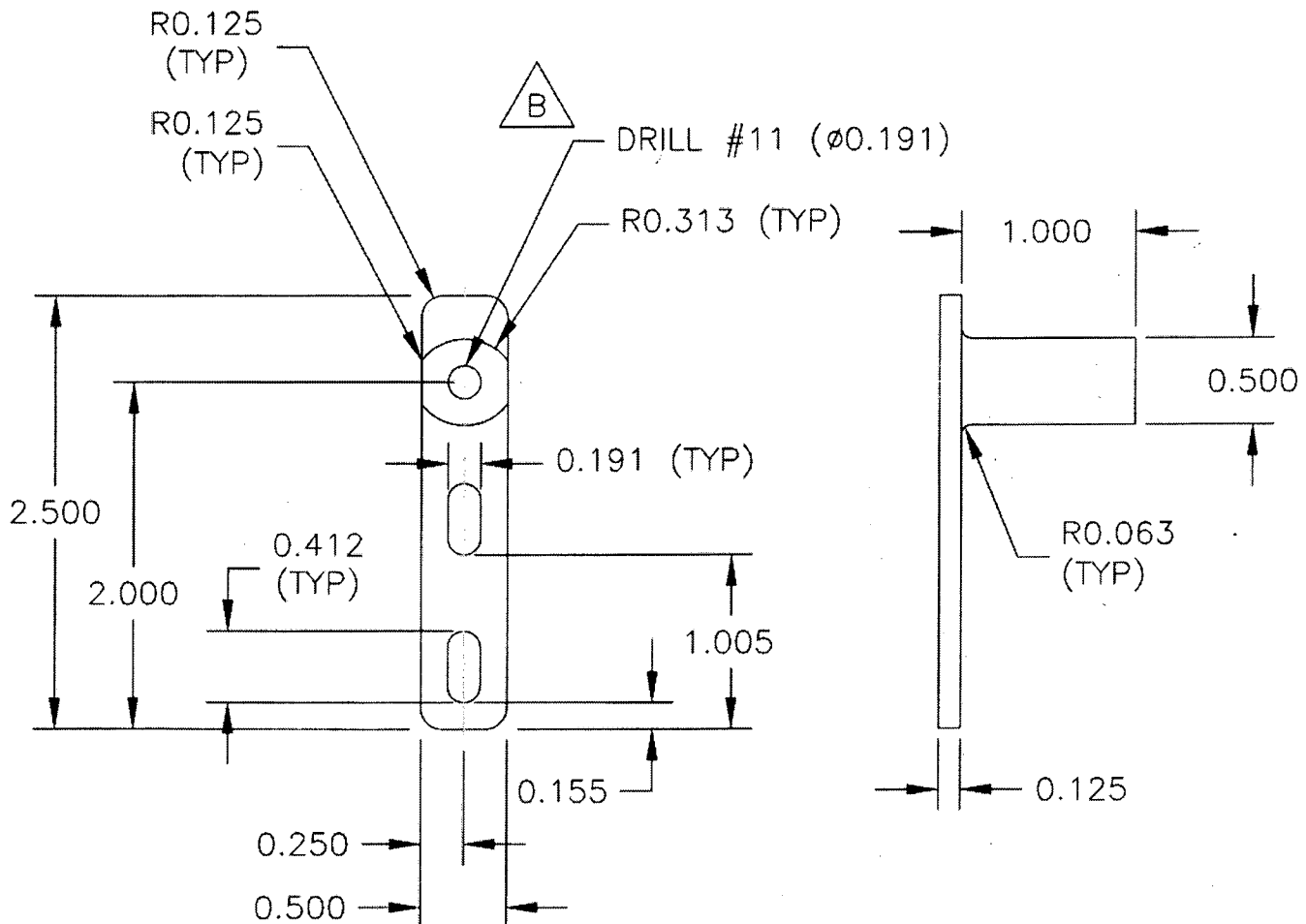
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3112	REV. B SHEET 1 OF 1
DATE 04.10.18		TITLE GUIDE	SCALE 1:1
A	02.04.12	NEW ISSUE	
B	04.10.18	ADD PART MARKING; $\phi 0.191$ WAS $\phi 0.185$	

RELEASED
04.11.23



D3112-1 GUIDE

NOTES:

- 1) MATERIAL: 6061-T6/T6511/T651 (QQ-A-225/8 OR QQ-A-200/8)
BAR (REF. DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-17
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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DART AEROSPACE LTD		Work Order: 41072
Description: Guide		Part Number: D3112-1
Inspection Dwg: D3112 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.006	✓			
0.500	+/-0.010	.500	✓			
R0.063	+/-0.010	.063	✓			
0.125	+/-0.010	.123	✓			
0.500	+/-0.010	.500	✓			
0.250	+/-0.010	.250	✓			
0.155	+/-0.010	.156	✓			
1.005	+/-0.010	1.006	✓			
0.412	+/-0.010	.412	✓			
0.191	+/-0.010	.192	✓			
2.000	+/-0.010	2.001	✓			
2.500	+/-0.010	2.501	✓			
Ø0.191	+0.005/-0.000	.191	✓			
R0.125	+/-0.010	.125	✓			

Measured by: J.L.	Audited by: <i>[Signature]</i>	Prototype Approval: N/A
Date: 08/08/15	Date: 08/08/16	Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.07.07	New Issue	KJ/JLM	